



Dart Aerospace Ltd.
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D3564-11

Job Sheet 201236



Part No: D3564-11

Job Qty: 12 pcs

Part Name: Wearplate Aft



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/27/19

Job Tracking No:

Due Date: 10/21/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E IPP Rev:A New Issue 07-03-08 ec IPP Rev:B As per Rev C 07-07-09 JLM IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC IPP Rev:D Comments revised on Step 5, 6 per B44656 09-02-06 KJ Verified By:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs		10/21/19	0.17	2.09	Waterjet - Flow		OCT 19/10/16
120	QC 8	12 pcs		10/21/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		OCT 17 2019
							QC 8 - 52		9-80
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
130	Small Fab - Brake NC -	12		10/21/19	0.25	0.80	Small Fab - Brake - 1 -		OCT 29 2019



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Container No: S222906



Part: D3564-11

Job No: 201236

Serial No/Batch: S222906

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/21/19

9/27/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

B4B	pcs				B4B	
					Small Fab - Brake - 2 - B4B	
					Small Fab - Brake - 3 - B4B	
					QC 5 - 10	
140 QC 5	12 pcs	10/21/19	0.00 0.00		QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	OCT 31 2019 DAS 68
					QC 5 - 9	9-89
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
150 Automated Welding - B4B	12 pcs	10/21/19	0.00 5.10		Automated Welding - 1 - B4B	<i>ML</i>
160 QC 10	12 pcs	10/21/19	0.00 0.00		QC 10 - 10	
					QC 10 - 18	
					QC 10 - 24	
					QC 10 - 43	
					QC 10 - 50	<i>a</i>
					QC 10 - 58	
170 QC 5	12 pcs	10/21/19	0.00 0.00		QC 10 - 9	
					QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	<i>a</i>
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	DAS
180 Spray Paint - 2 - B4B	12 pcs	10/21/19	0.00 1.20		Spray Paint - 1 - B4B	41 NOV 21 2019
					Spray Paint - 2 - B4B	3-89
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
190 QC 5	12 pcs	10/21/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	

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				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
200	Packaging 3-1 - Stock - B4B	12 pcs	10/21/19	0.00 0.00	Packaging 3 - 1 - B4B <i>FP-002</i> Packaging 3 - 2 - B4B Packaging 3 - 3 - B4B Packaging 3 - 4 - B4B Packaging 3 - 5 - B4B Packaging 3 - 6 - B4B Packaging 3 - 7 - B4B Packaging 3 - 8 - B4B Packaging 3 - 9 - B4B Packaging 3 - 10 - B4B Packaging 3 - 11 - B4B Packaging 3 - 12 - B4B Packaging 3 - 13 - B4B Packaging 3 - 14 - B4B Packaging 3 - 15 - B4B Packaging 3 - 16 - B4B Packaging 3 - 17 - B4B Packaging 3 - 18 - B4B Packaging 3 - 19 - B4B Packaging 3 - 20 - B4B Packaging 3 - 21 - B4B Packaging 3 - 22 - B4B Packaging 3 - 23 - B4B Packaging 3 - 24 - B4B Packaging 3 - 25 - B4B Packaging 3 - 26 - B4B Packaging 3 - 27 - B4B Packaging 3 - 28 - B4B Packaging 3 - 29 - B4B Packaging 3 - 30 - B4B Packaging 3 - 31 - B4B Packaging 3 - 32 - B4B Packaging 3 - 33 - B4B Packaging 3 - 34 - B4B Packaging 3 - 35 - B4B Packaging 3 - 36 - B4B
210	QC 21 - SA	12 pcs	10/21/19	0.00 0.00	QC 21 - SA - 21 QC 21 - SA - 70 QC 21 - SA - 53

DAS
NOV 27 2019
9:58

11 19-11-22

DAS
21
5:58

Part Op 100 - 1-Cut D3564-1 as per Dwg D3564 Dwg Rev: *E* Prog Rev: *E* 2-Deburr if necessary
 Descriptions: 120 - (QC8- Inspect parts - second check)
 130 - Form on Brake as per Dwg D3564 using Jigs DT8179
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - (Automated welding) 1- AUTOWELD AS PER DWG AND QSI004 8259 HARDCOAT BATCH: *PL139025*
 160 - (QC10- Inspect visual per QSI004- ground welds)

170 - (QC5- Inspect part completeness to step on W/O)
 180 - (Spray Paint / NDT Room) APPLY COATING ON CONCAVE SURFACE AS PER DWG AND QSI005 (SEE NOTE 12 ON DWG) **5227557**
 190 - (QC5- Inspect part completeness to step on W/O)
 200 - (Identify as per dwg & Stock Location: _____)
 210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	16.9200 sf (1.41 ea)	100-Waterjet - Flow - 1	S200442

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	17	452	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearshoe	3.227inches ± 0.010	3.237 3.217		
2	Wearshoe	2.432inches ± 0.010	2.442 2.422		
3	Wearshoe	2.500inches ± 0.010	2.510 2.490		
4	Wearshoe	6.000inches ± 0.010	6.010 5.990		
5	Wearshoe	12.104inches ± 0.010	12.114 12.094		
6	Wearshoe	18.000inches ± 0.010	18.010 17.990		
7	Wearshoe	18.000inches ± 0.030	18.030 17.970		
8	Wearshoe	9.000inches ± 0.030	9.030 8.970		
9	Wearshoe	11.500inches ± 0.030	11.530 11.470		
10	Wearshoe	0.300inches ± 0.010	0.310 0.290		
11	Wearshoe	0.300inches ± 0.010	0.310 0.290		
12	Wearshoe	0.188inches + 0.005 - 0.001	0.193 0.187		
13	Wearshoe	0.375inches ± 0.010	0.385 0.365		
14	Wearshoe	0.063inches ± 0.010	0.073 0.053		

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____		DISPOSITION		DEPARTMENT/PROCESS	
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Cross tube ☐ Small Fab ☐ Finishing ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QSI042)	
Description Work Order Deviation		Disposition			
Root Cause		FAULT CATEGORY			
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____			
		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐			
		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐			
		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			